Work Order ID

Page 1

December 21, 2009 9:04:54 AM

Item I	D:
--------	----

D3859-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Wearplate

Start Date: 12/21/09 Required Date: 12/31/09 Start Qty: 7.00

Req'd Qty: 7.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Date:

Date:

Tooling:

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours**

SPC (Y/N):

Draw Number Draw Rev.

Plan Accept Code Oty

Reject Qty

Reject Number Stamp

Draw Nbr

Revision Nbr

100

0.00

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

1-Cut as per Dwg D3859 []Dwg Rev:

0.00

_LIProg Rev: 🕰

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

10-1-5

110

Memo

0.00

0.00

B 10-1-5

Quality Control

120

QC

QC8- Inspect parts - second check

0.00

27 8 10/0/los

Memo

Quality Control

W/O:			W	ORK ORDER CHANG	GES				
DATE STEP		PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				4					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C C	losed:		Date:	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NC	R)		•	
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
DAIL	JILF .	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
l									

Page 3

December 21, 2009 9:05:00 AM

Item ID:

D3859-041

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Wearplate

12/21/09

Start Qty: 7.00

Req'd Qty: 7.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Date:

Tooling:

Date:

Start

Run

QC:

Required Date: 12/31/09

Process Plan:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Number Stamp

Insp.

Reject

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

Memo 2:150 m LIOVEN TEMPERATURE: START TIME: 21. 21.45 DFINISH TIME:

=> Ht 10/01/14 (15

Draw

Rev.

Plan

Code

Qty

Accept

Reject

Qty

170

Quality Control

QC3- Inspect Part Finish

Memo

SF 10-01-14

180

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

18-1-15

Memo

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	_ NCR: Yes No DQA:	Date:
Reso	lution:	Disposition:	QA: N/C Closed:	Date:

		WORK ORDI	ER NON-CONFORMANC	E (NCR)			
DATE STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
					:		
ļ							
							i.
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Chief Eng

Work Order ID 54757 December 21, 2009 9:05:00 AM

Page 4

Item ID:

D3859-041

Accept

Setup Start



Revision ID:

Item Name: **Start Date:**

Wearplate

12/21/09

Start Qty: 7.00

Required Date: 12/31/09 Req'd Qty: 7.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date: Date:

Start

Run

Stop

Stop



Sequence ID/

Operation **Work Center ID** Description

QC:

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

190

Memo

0.00

0.00

10-1-16

Quality Control

W/O: WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:
	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
	Description of NC	Corrective Action Section B			Verification	Approval	nnusual Annusual	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
·								
	1							

Picklist Print

December 21, 2009 9:04:52 AM

Work Order ID: 54757

Parent Item:

D3859-041

Parent Item Name: Wearplate

Comments:



Start Date: 12/21/09

Required Date: 12/31/09

Remaining

Required Qty: 7.00

Date

Issued

irt Qty: 7	.00
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Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Primary Bin Item Location

No

Last Location

Route Seq ID

Unit of Qty on Measure Hand

Qty To Pick Issued

Status

Page 1

M304S16GA

304/316 Sheet .063

Purchased

100

sf

370.2779 5.9500

Qty

四10-1-5

		Warehouse	Lo	<u>Oty</u>	Loc Code		
		Location					
		Main Warehouse					6 -
		MAT	370.27	78737			$\langle \hat{i} \rangle$
		106860	;	3.0295			(16)
		111924	25.16	89737		***************************************	
		112442	29	9.8899			
		113295	307	7.1895		43295	
Manufactured	No		130	Each	505.0000 42.000)	
						EL	90-1-11

D3009-3

Cup

Warehouse	Loc Qty	Loc Cod
Location		

Main Warehouse ST 42376

42377

505 102 403 <u>de</u>

W/O:		WORK ORDER CI	HANGES				
DATE	STEP					Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
Pos	solution:	Disposition:	QA: N/C Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC		Verification	Annuoval	Annuaval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
		, · · · · · · · · · · · · · · · · · · ·								
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							!			

DART AEROSPACE LTD	Work Order: 54757	
Description: Wearplate	Part Number: D3859-1	
Inspection Dwg: D3859 Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.879	+0.010/-0.001	588.	>			
0.75	+/-0.030	749	×			
4.250	+/-0.010	4245	K 5			
3.00	+/-0.030	3.012	٤			
5.75	+/-0.030	5.745	سوا			
9.000	+/-0.010	8.494	بر			
1.50	+/-0.030	1.50	৮			
20.40	+/-0.030	26.375				
0.063	+/-0.010	36.375 Owo	علا			
			#			
·						
			-			
			-			
						· · · · · · · · · · · · · · · · · · ·
					7.0	· · · · · · · · · · · · · · · · · · ·

Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	10-1-5	Date:	coloclas	Date:	N/A

Rev	Date	Change		Revised b	ŊΛ	Approved
Α	09.05.20	New Issue	P/O D3859-041		*	
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